Duplicate

Work Order ID 69799

July-03-12 1:04:37 PM

69799

Item ID: D6008-132 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube extrusion

Start Date: 5/19/11 **Start Qty:** 20.00 *20*

Required Date: 7/12/12 **Req'd Qty:** 20.00 *20*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D6008	Rev A								
100		0.00							
100	PURCHASING								
Purchasing									
Purchasing	**Memo**	0.00							

4 17-05-19

Issue P/O: 14138

a) Order as per Dwg D6008
b) Material: 3.250 x 0.438 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube
c) Minimum ultimate tensile strength = 77 ksi
d) Minimum tensile yield strength = 66 ksi
e) Tolerance are per ASTM B210 (see details on Dwg D6008)
f) Material certification required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging									
Packaging	**Memo**	0.00							

Ensure material certification is attached

20

7/12/12-18

Item ID: D6008-132 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Crosstube extrusion
Start Date: 5/19/11 **Start Qty:** 20.00 *20*
Required Date: 7/12/12 **Req'd Qty:** 20.00 *20*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	**Memo**	0.00							
Quality Control	Ensure Material certification comply to Dwg D6005								
130	Identify as per dwg & Stock Location: 46	0.00							
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

5 12/10/18 (20) 12-10-18 (8) 12/12/11 (20)

Picklist Print

July-03-12 1:04:36 PM

Work Order ID: 69799

Parent Item: D6008-132

Parent Item Name: Crosstube extrusion

Start Date: 5/19/11 **Required Date:** 7/12/12

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev:A New Issue 07-06-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-132P Crosstube extrusion		Purchased	No			110	Each	20.0000	1	20	20	6/12/12	

Location	Loc Qty	Loc Code
lhall	20	
69799	20	

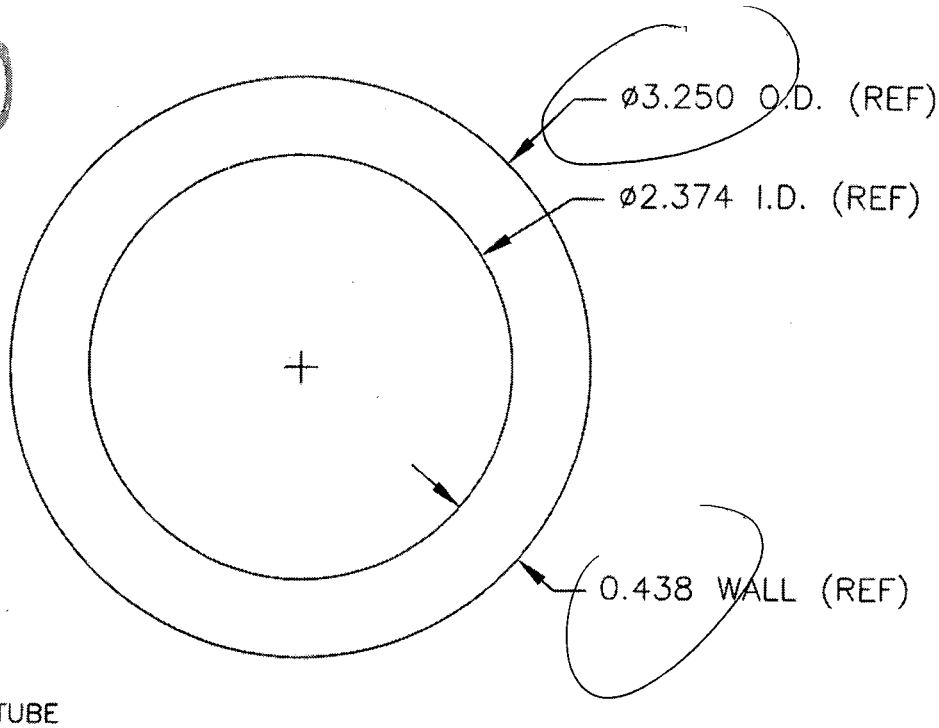
DESIGN GP	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D6008	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

DART

COPY ISSUED

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24



NOTES

1) D6008–XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008–180

69799

2) MATERIAL: 3.250 OD x 0.438 WALL 7075–T6/T6511 (WW–T–700/7 OR QQ–A–225/9 OR QQ–A–200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (±0.016 INCLUDING OVALITY)
WALL: ±0.020 MEAN (±0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.125/–0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

EXTRUSION INSPECTION SHEET

TUBE #	TOTAL LENGTH	DIA two readings	INSIDE DIA	wall thickness measured w/vern	Strightness at 12"	Rockwell Reading	LOCATION on tube	ULTRA SONIC MEASURMENTS R1	R2	R3	R4
DWG	132.00"	3.250" OD	2.374" ID	0.438"	0.010"	N/A	66" Middle				
1	132.00"	3.249"/3.243"	2.369"	0.431"/0.441"	0.022"	N/A	66" Middle	0.453"	0.444"	0.446"	0.453"
2	132.00"	3.245"/3.251"	2.365"	0.431"/0.444"	0.035"	N/A	66" Middle	0.450"	0.453"	0.446"	0.442"
3	132.00"	3.247"/3.249"	2.365"	0.38"/0.441"	0.012"	N/A	66" Middle	0.446"	0.446"	0.449"	0.448"
4	132.00"	3.251"/3.246"	2.364"	0.465"/0.423"	0.030"	N/A	66" Middle	0.441"	0.457"	0.446"	0.438"
5	132.00"	3.256"/3.252"	2.362"	0.452"/0.440"	0.029"	N/A	66" Middle	0.450"	0.450"	0.448"	0.448"
6	132.00"	3.243"/3.247"	2.360"	0.438"/0.444"	0.032"	N/A	66" Middle	0.451"	0.446"	0.446"	0.448"
7	132.00"	3.243"/3.249"	2.363"	0.439"/0.443"	0.034"	N/A	66" Middle	0.436"	0.451"	0.455"	0.444"
8	132.00"	3.252"/3.244"	2.356"	0.451"/0.437"	0.029"	N/A	66" Middle	0.444"	0.446"	0.446"	0.449"
9	132.00"	3.242"/3.238"	2.358"	0.444"/0.438"	0.034"	N/A	66" Middle	0.435"	0.449"	0.455"	0.444"
10	132.00"	3.252"/3.249"	2.358"	0.452"/0.435"	0.032"	N/A	66" Middle	0.442"	0.448"	0.448"	0.444"
11											
12											
13											
14											
15											

PART # D6008-132 | P/O# 14138 | BATCH # 69779 | Notes: tube #4 found to have a wall tickness issue see attached sheet

EXTRUSION INSPECTION SHEET

		SIDE A	SIDE B			SIDE A / B		ULTRA SONIC MEASURMENTS				
TUBE #	TOTAL LENGTH	DIA two readings	DIA two readings	INSIDE DIA	wall thickness measured w/vern	Strightness at 12"	Rockwell Reading	LOCATION on tube	R1	R2	R3	R4
DWG							N/A	Middle	N/A			
1		3.245 / 3.252	2.242 / 2.246	2.360	2.432 / 1.454	.024 / .012	N/A	Middle				
2		3.240 / 3.245	2.231 / 2.245	2.360	.440 / .443	.011 / .000	N/A	Middle				
3		3.243 / 3.244	2.248 / 2.241	2.360	.440 / .436	.010 / .014	N/A	Middle				
4		2.251 / 2.249	2.246 / 2.257	2.360	.444 / .447	.015 / .013	N/A	Middle				
5		2.245 / 2.250	2.247 / 2.243	2.364	.436 / .445	.023 / .010	N/A	Middle				
6		2.243 / 2.248	2.239 / 2.244	2.363	.436 / .447	.012 / .017	N/A	Middle				
7		2.244 / 2.240	2.246 / 2.251	2.360	.440 / .444	.026 / .012	N/A	Middle				
8		2.245 / 2.247	2.243 / 2.236	2.360	.441 / .445	.024 / .022	N/A	Middle				
9		2.241 / 2.244	2.243 / 2.246	2.360	.439 / .448	.033 / .012	N/A	Middle				
10		2.241 / 2.243	2.243 / 2.249	2.364	.437 / .448	.041 / .020	N/A	Middle				
11		2.246 / 2.251	2.240 / 2.247	2.363	.447 / .437	.037 / .016	N/A	Middle				
12		2.241 / 2.245	2.240 / 2.247	2.362	.435 / .441	.042 / .027	N/A	Middle				
13		2.244 / 2.249	2.251 / 2.244	2.361	.437 / .445	.014 / .012	N/A	Middle				
14		2.246 / 2.250	2.245 / 2.246	2.363	.439 / .445	.017 / .008	N/A	Middle				
15		2.250 / 2.247	2.244 / 2.246	2.360	.438 / .443	.026 / .020	N/A	Middle				
16		2.249 / 2.246	2.243 / 2.249	2.360	.436 / .215	.029 / .019	N/A	Middle				